



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3713

Job Sheet 200991



Part No: 646.3713

Job Qty: 20 pcs

Part Name: Gusset



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/20/19

Job Tracking No:

Due Date: 10/21/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG REV A SHEET 4 IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	20 pcs		10/21/19	0.17	0.80	Waterjet - Flow	10/13/19	JRB
120	QC 2	20 pcs		10/21/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com



Container No: S219291



Part: 646.3713

Job No: 200991

Serial No/Batch: S219291

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/03/19

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				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	10/13/19 JRB
130 QC 8	20 pcs	10/21/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	OCT 04 2019 40 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	DAS 30 9-89
140 Small Fab - Brake NC - B4B	20 pcs	10/21/19	0.25 2.00	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	20 pcs	10/21/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	

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					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	DAS
					QC 5 - 40	40
					QC 5 - 61	OCT 22 2019 9:39
					QC 5 - 81	
160	Outsource - 4 - Anodize	20 pcs	10/21/19		ATG001-VC	5
						2019-10-25
170	Packaging 2-1 - Receive - B4B	20 pcs	10/21/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	NOV 28 2019
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
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					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
180	QC 5	20 pcs	10/21/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	

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					QC 5 - 58		DAS
					QC 5 - 68	JAN 03 2020	68
					QC 5 - 9		9-89
					QC 5 - 50		
					QC 5 - 30		
					QC 5 - 40		
					QC 5 - 61		
					QC 5 - 81		
210 Packaging 3-1 - Stock - B4B	20 5 pcs	10/21/19	0.00 0.00	Packaging 3 - 1 - B4B			
				Packaging 3 - 2 - B4B			
				Packaging 3 - 3 - B4B ✓	CCK104	DAS	80
				Packaging 3 - 4 - B4B		9-89	
				Packaging 3 - 5 - B4B			
				Packaging 3 - 6 - B4B	JAN 03 2020		
				Packaging 3 - 7 - B4B			
				Packaging 3 - 8 - B4B			
				Packaging 3 - 9 - B4B			
				Packaging 3 - 10 - B4B			
				Packaging 3 - 11 - B4B			
				Packaging 3 - 12 - B4B			
				Packaging 3 - 13 - B4B			
				Packaging 3 - 14 - B4B			
				Packaging 3 - 15 - B4B			
				Packaging 3 - 16 - B4B			
				Packaging 3 - 17 - B4B			
				Packaging 3 - 18 - B4B			
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				Packaging 3 - 21 - B4B			
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				Packaging 3 - 27 - B4B			
				Packaging 3 - 28 - B4B			
				Packaging 3 - 29 - B4B			
				Packaging 3 - 30 - B4B			
				Packaging 3 - 31 - B4B			
				Packaging 3 - 32 - B4B			
				Packaging 3 - 33 - B4B			
				Packaging 3 - 34 - B4B			
				Packaging 3 - 35 - B4B			
				Packaging 3 - 36 - B4B			
220 QC 21 - SA	20 5 pcs	10/21/19	0.00 0.00	QC 21 - SA - 21 ✓	CCK104	DAS	70
				QC 21 - SA - 70	JAN 03 2020	9-89	
				QC 21 - SA - 53			
Part Op 110 - 1-Cut as per Dwg Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Bend/Assemble as per dwg) 150 - (QC5- Inspect part completeness to step on W/O) 160 - Issue P/O to ATG : 44899 Hard Anodize, Color Black and Prime as per Dwg 646.3700 170 - (Receive & Inspect for Damage & Mat'l Certs) 180 - (QC5- Inspect part completeness to step on W/O) 210 - Identify as per dwg & Stock Location:) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P#							

AND REV***

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	5.9800 sf (.299 ea)	110-Waterjet - Flow - 1	5176525x12 5190194x10

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M6061T6S.063	6	368	0

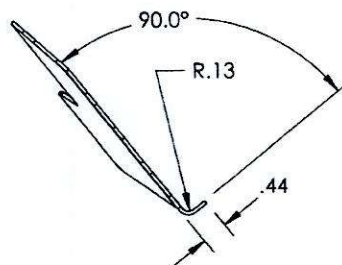
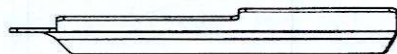
Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Gusset	1Inches ± 0	1 1		
2	Gusset	2Inches ± 0	2 2		
3	Gusset	4Inches ± 0	4 4		
4	Gusset	5Inches ± 0	5 4		
5	gusset	7Inches ± 0	7 6		
6	Gusset	3Inches ± 0	3 3		
7	Gusset	6Inches ± 0	6 6		
8	Gusset	7Inches ± 0	7 7		
9	Gusset	0Inches ± 0	0 0		

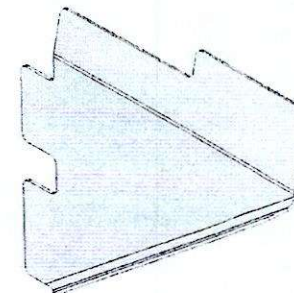
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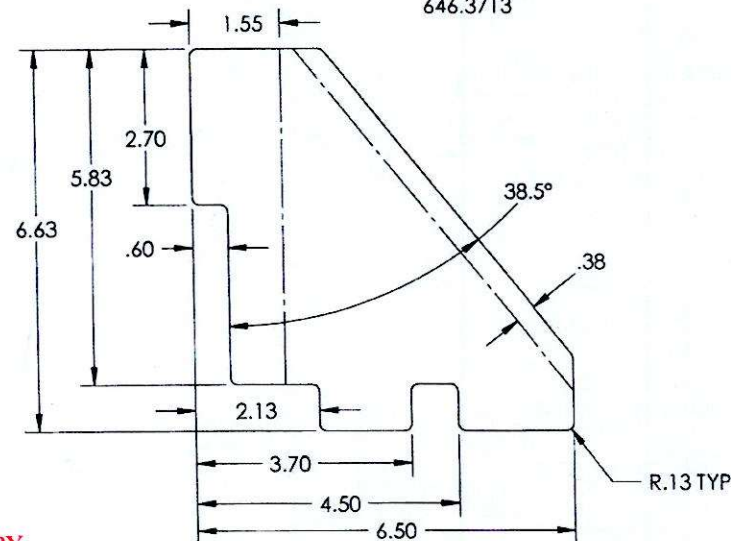
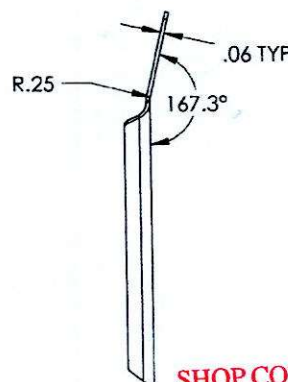
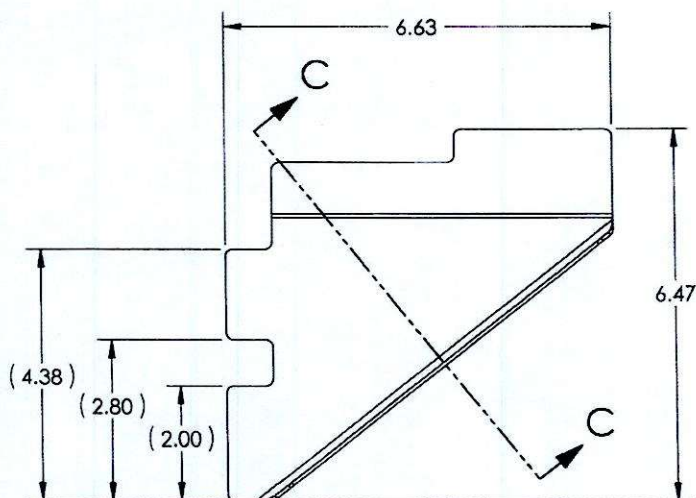
REV	DESCRIPTION	DATE	APPROVED



SECTION C-C



646.3713



FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 200 991

NEXT ASSY (S)	ORIGINAL DATE (DATE OF)	08-18-08
	DRAWN BY	P. BAJO
	CHECKED BY	S. JOHNS
	DATE OF APPROVAL	08-18-08
CONTRACT NO.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS AND ANGLES ± .5°		
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300		
SHEETMETAL		
SHEET	CAGE CODE	DWG NO.
B	07M26	646.3700
SCALE: INCHES		REV A
		SHEET 4 OF 9

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	